

Wednesday, 17/09/2008 3:56:37 PM
Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 42079
Estimate Number : 13582

P.O. Number :
This Issue : 17/09/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL / MED FAB

Previous Run :
Written By : *JLM 08-09-17*

Checked & Approved By :
Comment : Est Rev:A New Issue 08-09-17 JLM Verified By:EC

Additional Product

Drawing Name : BRACKET

Part Number : D38201
Drawing Number : D3820 PREL
Project Number : N/A
Drawing Revision : PREL
Material :
Due Date : 24/09/2008

Qty: 3 Um: Each

~~FOR EXTERNAL USE ONLY~~~~FOR EXTERNAL USE ONLY~~*proto u*~~PRELIMINARY ISSUE~~

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet

*S MAT NOT PULLED*

Comment: Qty.: 0.0543 sf(s)/Unit Total : 0.1629 sf(s) *IB 8-10-2*
6061-T6 .125 Sheet *108730 IB 8-9-29*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3820 *IB 8-10-2*
Dwg Rev: PREL *IB 8-9-29*
Prog Rev: PREL *IB 8-9-29*

2-Deburr if necessary *IB 8-9-29*

(3)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*IB 8-10-2**IB 8-9-29*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

*J0810-01 (3)**J0810-02 3*

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE

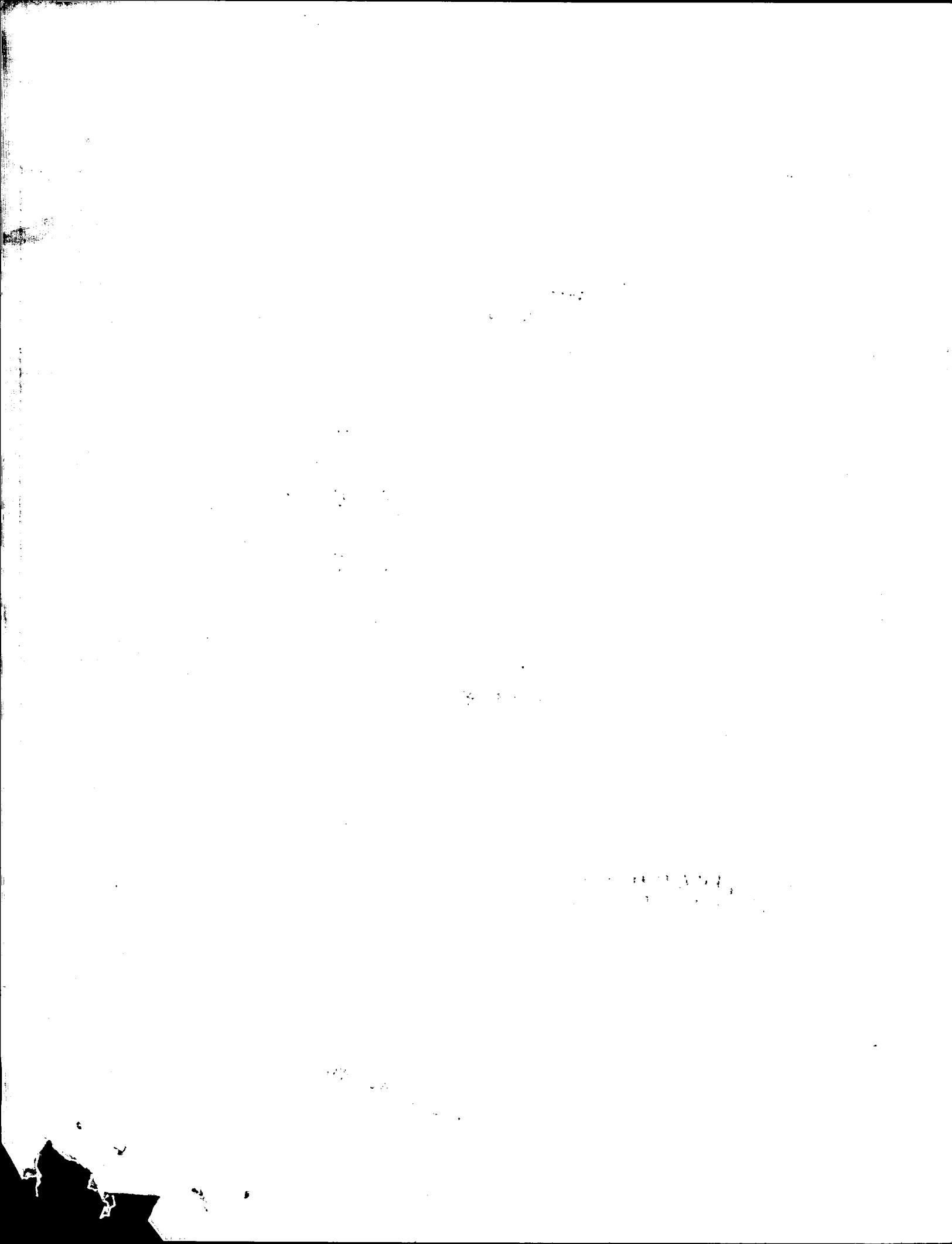


Comment: NC BRAKE

Bend as per Dwg D3820

SB 08/10/03

(3)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42079

Part Number: D38201

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



108.10.06 (3)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/10/06 (3)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *MK u per mark*OVEN TEMPERATURE: *500.0*FINISH TIME: *8.10.06*

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1 PACKAGING RESOURCE #1

*HARLEY -> Eagle.*

Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: *Stock*

AS 08/10/06 (X3)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

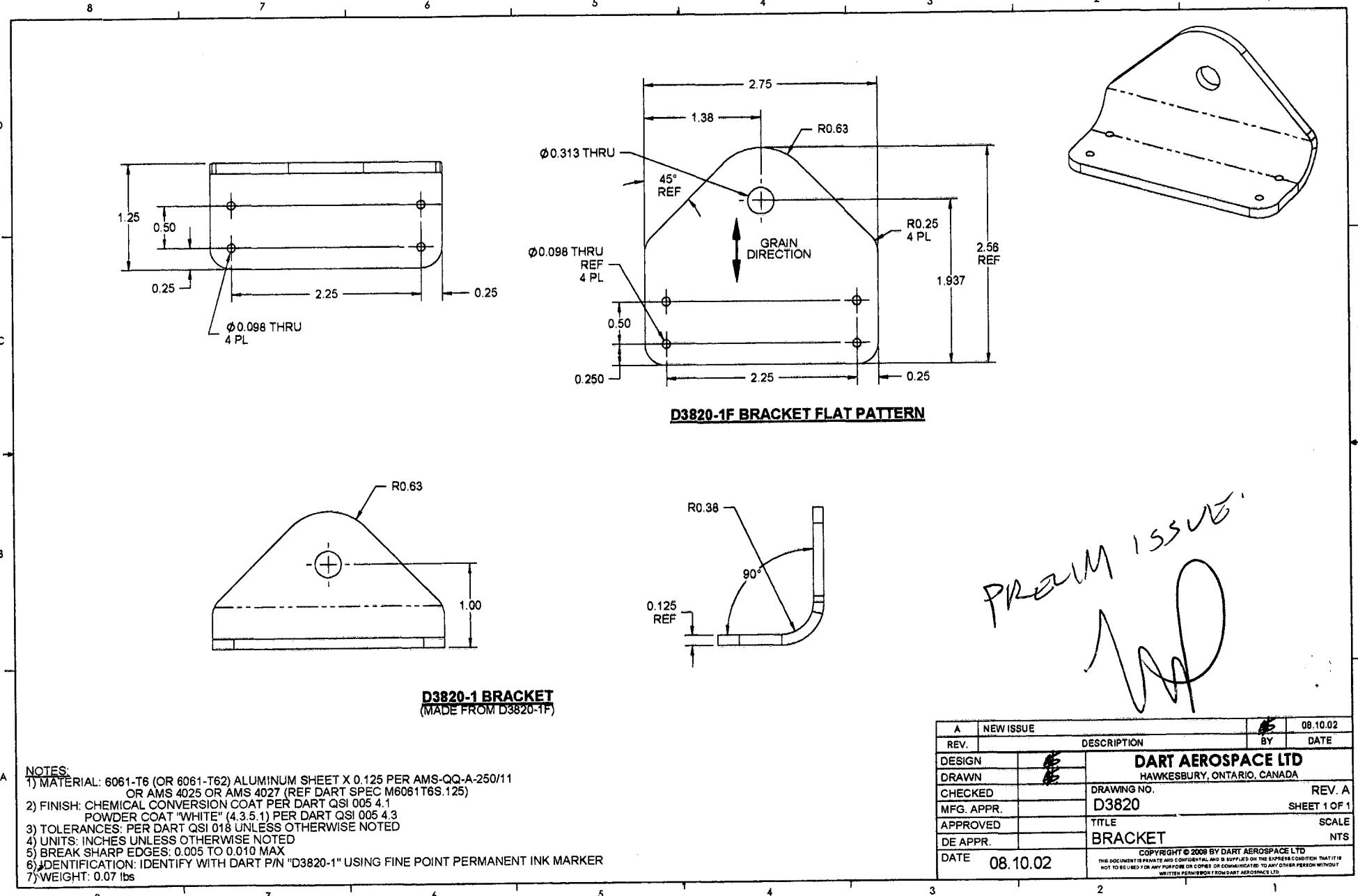
*u 08.10.06*
POSITIVE RECALLEFFECTIVE DATE *08/10/06*RELEASED *002524*

AUTHOR

DATE

3 parts Scrap due to we did not have.
"4" Dies Eng charged to 375

Jay.



DART AEROSPACE LTD	Work Order:	42079
Description: BRACKET	Part Number:	D3820-1
Inspection Dwg: D3820-1 Rev: DRE		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>B</u>	Audited by:	<u>/</u>	Prototype Approval:	
Date:	9-10-2	Date:	08-10-02	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/06	J.O	Reports scrap. - Parts did not meet the req due to incorrect die's being used. DWG asked for R .250", and a R. 3/8"	J 08/10/06	- Scrap & replace 2x sets of 3.	R N T O 8	J 08-10-06	J 08/10/06	J 08/10-06
.	.	WAS used, and also identified AS a $\frac{1}{8}$ " die. Q.C: Tools are not identified correctly, and are clearly not measured to ensure the tool is the correct size.	J 08/10/06	- Ensure all tools ^{and} material are measured prior to use, regardless of the identification.	J 08/10/06	J 08-10-06	J 08/10/06	J 08-10-06

NOTE: Date & initial all entries

